

Serial No. 10/630,267
67028-014

IN THE CLAIMS:

The following is a complete listing of the pending claims along with status.

1-32. (CANCELLED)

33. (PREVIOUSLY PRESENTED) A method molding a molded article comprising:

- a) introducing molten material into a mold cavity;
- b) receiving a predetermined amount of molten material into a passage adjacent said mold cavity;
- c) displacing said predetermined amount of material from said passage and into said mold cavity during solidification of said molten material;
- d) providing for travel of a movable member within said passage substantially equal to twice a determined amount of height loss caused by material shrinkage; and
- e) determining an amount of said molten material received within said passage according to a relationship between material shrinkage and mold injection pressures comprising determining a biasing force for biasing movement of said movable member against injection pressures such that movement of said movable member within said passage is substantially equal to twice the amount of height loss caused by material shrinkage.

34. (PREVIOUSLY PRESENTED) The method as recited in claim 33, wherein said biasing force is determined as a percentage of molding injection pressures.

35-36. (CANCELLED)

Serial No. 10/630,267
67028-014

37. (PREVIOUSLY PRESENTED) A method of compensating for material shrinkage during a plastic molding, said method comprising the steps of:

- a) introducing molten plastic material into a mold cavity;
- b) determining a volume of material required to compensate for material shrinkage in a localized region according to a relationship between material shrinkage properties of the plastic material and injection pressures utilized to introduce molten plastic into the mold cavity;
- c) determining a biasing force for biasing a movable member against the injection pressure such that displacement of the movable member provides for receipt of a volume of plastic material greater than or equal to two times the volume determined to compensate for material shrinkage;
- d) displacing a movable member into a passage adjacent the mold cavity to received the determined volume of plastic material; and
- e) expelling a portion of the determined volume back into the mold cavity during solidification of the plastic material..